Tuesday, July 1.	3, 2010 11:09	9:33 AM										
Item ID:	D3955-041		A	Accept					Setup	Start		
Revision ID:					(1221127					Stop		
Item Name:	Doubler Asse	mbly								o vo p		
Start Date: Required Date	7/13/2010 :: 7/20/2010	Start Qty: 4.00 Req'd Qty: 4.00			Cust Iter							
Reference:						1	_		Run	Start		A
Approvals:	Process Pl	an:	Date:0-7-13	Tooling:		Date:			Kun			
	QC:	70	Date:	<b>SPC (Y/N):</b>		Date:				Stop		
Sequence ID/ Work Center I	ID	Operation Description		Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Rej Qt	•	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr	·			٠.		d				
D3955	. A											
100 Waterjet FLOW CNC Wate		<b>Memo</b> 1-Cut as <sub>1</sub> Dwg Rev Prog Rev	per Dwg D3955-1 : <b>A</b>	0.00 0.00				M		10	07	144
	*	2-Deburr	if necessary			1						
110 Harri Harri 1881	I	QC2- Inspect parts of	f machine FAI/FAIB	0.00				M		10	07	914 (2
QC	l	Memo		0.00				6111				- * <del>~ / / ·</del> · ·
Quality Control				4						4		

W/O:			V	ORK ORDER CHAN	GES		·			
DATE	STEP	PRC	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQA	:	Date:	
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NCR:		\	WORK OR	DER NON-CONFORM	/ANCE	(NCR	)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se  Action Description Chief Eng	ection B	Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
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Page 2

Item ID:

D3955-041

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

**Doubler Assembly** 

**Start Date:** 

7/13/2010

Start Qty: 4.00

Required Date: 7/20/2010

Req'd Qty: 4.00



Date:

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_ SPC (Y/N):

Tooling:

Date: Date:

Code

Start Stop



Sequence ID/ **Work Center ID** 

120

Quality Control

Operation **Description** 

Memo

Memo

QC8- Inspect parts - second check

Set Up/ **Run Hours** 

0.00

0.00

Tool # Plan

Accept Qty

Reject Qty

Run

Reject Insp. Number Stamp

130

Small Fab

Small Fab

1- C'sink holes as per dwg

2- Deburr if necessary

0.00

0.00

=7m/ 60/07/14

140

QC5- Inspect part completeness to step on W/O

Memo

QC

Quality Control

#### **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES Approval Approval** PROCEDURE CHANGE Qty STEP By Chief Eng / DATE Date QC Inspector Prod Mgr Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_ Date: \_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP** Sign & **Action Description** Initial Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng

#### Work Order ID 60519

Tuesday, July 13, 2010 11:09:33 AM



Page 3

Item ID:

D3955-041

Accept

Setup Start



**Revision ID:** 

Item Name:

Doubler Assembly

**Start Date:** 

7/13/2010

Start Qty: 4.00

Required Date: 7/20/2010

Req'd Qty: 4.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:\_\_\_\_\_

Date: **Tooling:** 

SPC (Y/N):

Date:

Run

Start

Stop



Stop

Sequence ID/

**Work Center ID** 

150

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/

**Run Hours** 

0.00

0.00 = 7m/h 10/07/

Tool ID

Date:

Tool # Plan Code Accept Reject Qty\_

Reject Insp. Number Stamp

160

Quality Control

QC3- Inspect Part Finish

Memo

Memo

0.00

So 10/01/14

0.00

170

Packaging

Packaging

Pick Kit

Memo

0.00 7M/ W/07/14

W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CHA	NGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	o <b>DQ</b>	<b>\:</b>	_ Date: _	
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DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
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Work	Order	ID	60519
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Tuesday, July 13, 2010 11:09:33 AM



Page 4

Item ID:

D3955-041

Accept

Setup Start



**Revision ID:** 

Item Name:

Doubler Assembly

**Start Date:** 

7/13/2010

Start Qty: 4.00

Required Date: 7/20/2010

Req'd Qty: 4.00



Cust Item ID:

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Tool # Plan

Code

Date:

Run

Start

Stop



Stop

Sequence ID/ Work Center ID

180

Small Fab

Small Fab

Operation

Description

Memo

Memo

Set Up/

Date: \_\_\_\_

**Run Hours** 

0.00

**Tool ID** 

Accept Qty

Reject Qty

Reject Insp. Number Stamp

190

Quality Control

QC5- Inspect part completeness to step on W/O

1- Assemble nut plate as per dwg

200

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

0.00

	-									
W/O:			W	ORK ORDER CHANG	ES			······································		1
DATE	STEP	PRO	OCEDURE CHA	ANGE		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	egory:	_ NCR:	Yes N	o <b>DQ</b>	ı:	Date:	
	R	esolution:	Disposition	on:	_ QA: N	I/C Clo	sed:		Date:	
NCR:		1	WORK ORD	ER NON-CONFORMA	NCE (	NCR)				-
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description  Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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Work	Ord	er ID	6051	Q
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Tuesday, July 13, 2010 11:09:33 AM



Page 5

Item ID:

D3955-041

Accept

Setup Start



**Revision ID:** 

Item Name:

Doubler Assembly

**Start Date:** 

7/13/2010

Start Qty: 4.00

Required Date: 7/20/2010 Req'd Qty: 4.00

Operation

Description

**Cust Item ID:** 

Customer:

Reference:

Approvals:

QC:

Date:\_

Date:

Tooling: SPC (Y/N):

Set Up/

Run Hours

Date: Date: Run

Start

Stop



Stop

Sequence ID/

Work Center ID

210

Memo

QC21- Final Inspection - Work Order Release

Tool ID

Tool # Plan

Accept Code | Qty

Reject Qty

Reject Însp. Number

Stamp

Quality Control

0.00

0.00

# Dart Aerospace Ltd W/O: WORK ORDER CHANGES DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr QC Inspector Approval QC Inspector

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA	: Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

				CE (NCR)				
- [	Description of NC		Corrective Action Section B	V =	Verific	ation	Approval	Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			Chief Eng	QC Inspector
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### **Picklist Print**

Tuesday, July 13, 2010 11:09:37 AM

Work Order ID: 60519

Parent Item:

D3955-041

Parent Item Name: Doubler Assembly



**Start Date:** 7/13/2010

Required Date: 7/20/2010

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:	IPP RevA: New issu	ue DD verified b	y:EC				! }				i.		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf !	118.7600	0.3553	1.496			-
				Location MAT21	113608		Oty 8.76 : 8.76	Loc Code			Vn/(	_ 10 · 1	57.14
MS21086L3  Nut Plate		Purchased	No		113000	180	Each	18.0000	F.	4			
				Location ST304	112219	<u>Loc (</u>	Oty ' . 18 18	Loc Code	_	ЦX	M/	1 10	107/10
MS20427M3-3		Purchased	No			180	Each	532.0000	2	8	777(2		
			•	Location ST318	112022	<u>Loc (</u>	532	Loc Code			·		
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W/O:			WO	RK ORDER CHANG	GES					
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DART AEROSPACE LTD	Work Order:	60519
Description: Doubler	Part Number:	D3955-1
Inspection Dwg: D3955 Rev: A		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

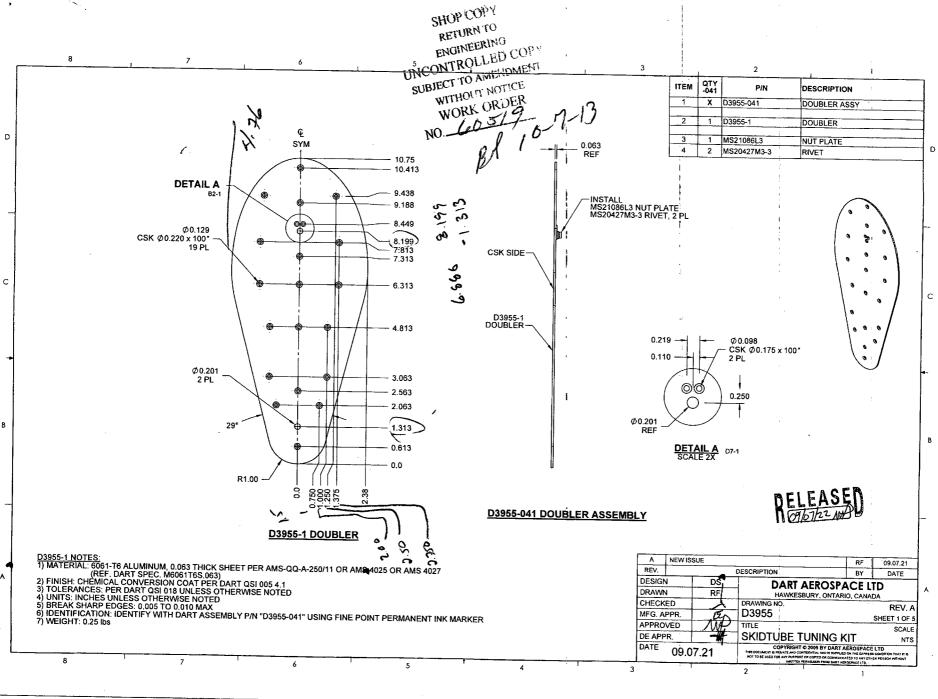
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.131	V		very	
Ø0.201	+0.005/-0.001	0.202	1		INN	
0.750	+/-0.010	0.748	V		H.G	
1.000	+/-0.010	1.003	V		H.G	
1.250	+/-0.010	1255	V		H.G	
1.375	+/-0.010	1.374	V		H.G	
2.38	+/-0.030	2.38	V	-	H.G	
0.613	+/-0.010	0.613	V		H.G	
1.313	+/-0.010	1,313	V .		H.G	
2.063	+/-0.010	2.063			HG	
2.563	+/-0.010	2.563			H.G	
3.063	+/-0.010	3.067	V		H,&	
4.813	+/-0.010	4.818	/		H.G	
6.313	+/-0.010	6.310	V		HĠ	
7.313	+/-0.010	7.3/2	V		H.G	
7.813	+/-0.010	7.8/3			HG	
8.199	+/-0.010	8 RO	1		M.G	
8.449	+/-0.010	8.200	/		H.G.	
9.188	+/-0.010	9.190	/		H.G	
9.438	+/-0.010	9.435	V		HG	
10.413	+/-0.010	10.413	/		M.+	· · · · · · · · · · · · · · · · · · ·
10.75	+/-0.030	10.75	V		MT	
0.063	+/-0.010	0.060			vers	

Measured by:	M.M	Audited by:		Prototype Approval:	N/A	
Date:	10.07.14	Date:	1207/14	Date:	N/A	

Rev	Date	Change		Revised	Aphroved
A	09.07.29	New Issue	P/O D3955-041	KJ 🛠	W
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W/O:				W	ORK ORDER CHANG	GES		···	
DATE	STEP	*	PRO	OCEDURE CH		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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W/O:		WORK ORDER CHANGES								
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Part No	:	PAR #:	PAR #: Fault Category: NCR: Yes No DQA				<b>-</b>	_ Date: _		
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SYM - 0.060 REF D D APPLY ANTI-SKID ON ONE SIDE ONLY-8.199 С ulo 60519 29° 1.313 Ø0.201 2 PL 0.0 R1.00 0.0 2.38 **D3955-3 COVER PLATE** NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
2) FINISH: BLACK ANTI-SKID PAINT PER DART GSI 005 4.4
3) TOLERANCES: PER DART GSI 018 UNILESS OTHERWISE NOTED
4) UNITS: INCHES UNILESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.64 lbs DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN RF CHECKED DRAWING NO. REV. A MFG. APPR. A D3955 SHEET 2 OF 5 APPROVED TITLE SCALE SKIDTUBE TUNING KIT DE APPR. NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD

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FOR TOBE USED FOR MY THE DIVINESS COMMON THAT IT IS

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Ø0.201 2 PL R1.00 -SYM 29° 1.31 10.75

**D3955-X PLATE** 

General Table								
P/N	T (in)	T (GA)	WEIGHT (Ibs)					
D3955-5	0.060	16	0.64					
D3955-7	0.120	11	1.28					

who 40519

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304S'T'GA)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: SEE TABLE

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DS RF DRAWN DRAWING NO. CHECKED REV. A MFG. APPR. APPROVED TITLE SKIDTUBE TUNING KIT DE APPR COPYRIGHT © 2009 BY DART AEROSPACE LTD

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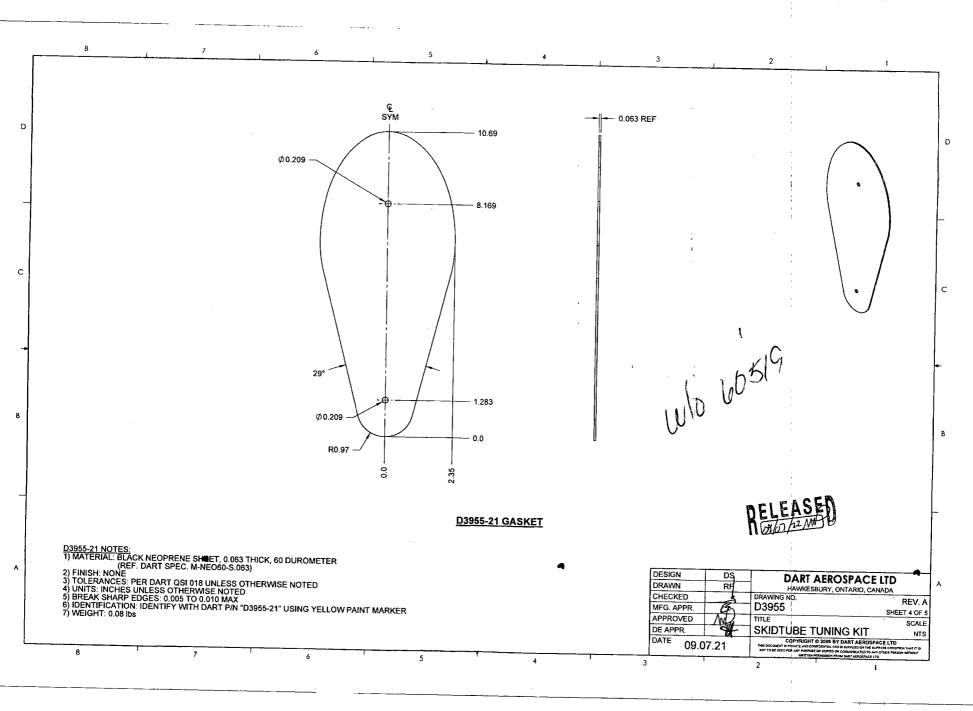
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SHEET 3 OF 5

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W/O:		WORK ORDER CHANGES								
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€ SYM - 0.040 REF 11.13 D 10.600 D 9.625 9.375 8.500 8.000 Ø0.098 19 PL 7.500 6.500 5.000 3.250 29° 2.750 2.250 1.500 Ø0.129 0.800 0.0 R1.19 0.0 2.563 D3955-23 TEMPLATE NOTES:
1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.16 lbs DESIGN DS, DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN RF CHECKED DRAWING NO. REV. A MFG. APPR. D3955 SHEET 5 OF 5 APPROVED TITLE SCALE DE APPR. SKIDTUBE TUNING KIT NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD
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